

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004038**Date Inspected:** 12-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Zhang Bao Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:****Grinding Demonstration**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for random observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector observed ZPMC in the OBG assembly bay 2 performing a grinding demonstration on the CJP splice for panels DP66-DP65. ABF representative Peter Shaw was noted as being present during this time and had relayed to this QA inspector that he had marked the 200 mm location for ZPMC to perform this demonstration. ZPMC had started this process at approximately 1500 hours and by the end of this QA inspectors shift had not completed the grinding

Bay 1 OBG sub-assembly

This QA inspector during his periodic observation at ZPMC observed the fabrication of deck panels in bay 1. The fabrication process was noted to be in several stages that included; closed rib milling, PJP weld joint beveling, drilling thru holes, press forming, closed rib splice welding, closed rib diaphragm fit-up and FCAW welding of splices, closed rib to deck plate fit-up/tack welding and the PJP welding of closed ribs to deck plates using GMAW and SAW processes. ZPMC had placed closed rib deck panel DP389-001 at gantry 2 that had been tack welded and was ready for the GMAW and SAW welding process. At gantry 1 DP605-001 and DP362-001 had been welded with the GMAW and SAW process which had been completed. DP362-001, ZPMC had performed MT of tack welds prior to welding and noted 50 linear indications out of 295 tack weld areas these areas had been ground and MT performed again prior to the welding process and found acceptable by ZPMC.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Grinding demo sloce-up view
Cap size after grinding approx
.2mm as measured by QA inspector



completed grinding demonstartion
DP65-DP66



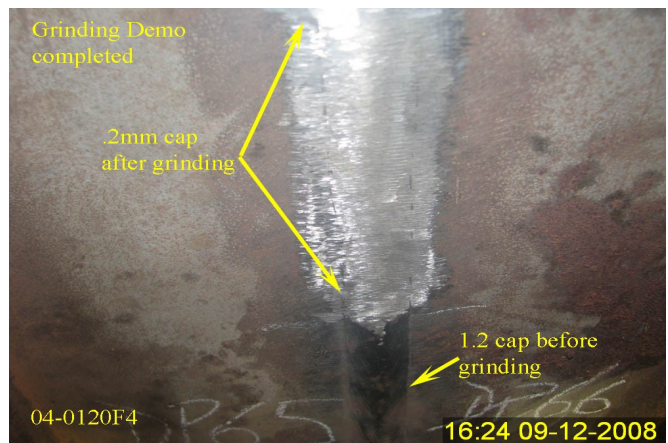
grinding demo showing approx length of 200mm



Grinding Demo
completed

.2mm cap
after grinding

1.2 cap before
grinding



Summary of Conversations:

As stated above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Riley,Ken

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer